

Date: Wednesday, 08/10/2008 3:18:48 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SLIDING DOOR BRACKET
Job Number	: 42515		
Estimate Number	: 13275		
P.O. Number	:	Part Number	: D36751
This Issue	: 08/10/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3675 REVA
First Issue	: 11	Project Number	: N/A
Previous Run	: 40347	Drawing Revision	: A
Written By	:	Material	:
Checked & Approved By	: <u>JUL 08.10.08</u>	Due Date	: 25/10/2008
Comment	: Est Rev:A new issue 08-04-21 DD verified by:EC	Qty:	84 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
-----	-----------	--------------------



Comment: Qty.: 0.1271 sf(s)/Unit Total: 9.1476 sf(s)

304 stainless steel 0.032" Sheet

Batch: 109057 B8-10-17

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3675

Dwg Rev: A

Prog Rev: A

B8-10-17

(84)

2-Deburr if necessary B8-10-17

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



B8-10-17

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5 08/10/17 (84) counted

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Form as per Dwg D3675

50 08/10/27 (84)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 08/10/2008 3:18:48 PM
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Drawing Name: SLIDING DOOR BRACKET

Job Number: 42515

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



coaxentes

08/10/27

(84)

Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



m 106442

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

9:20

OVEN TEMPERATURE:

320°

FINISH TIME:

9:50

FX 08/10/28

(84)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(84)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m-1 08/10/28

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 238A

JS 08/10/28 (84)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(84)

Comment: FINAL INSPECTION/W/O RELEASE

08/10/29

Job Completion



W 08.10.29

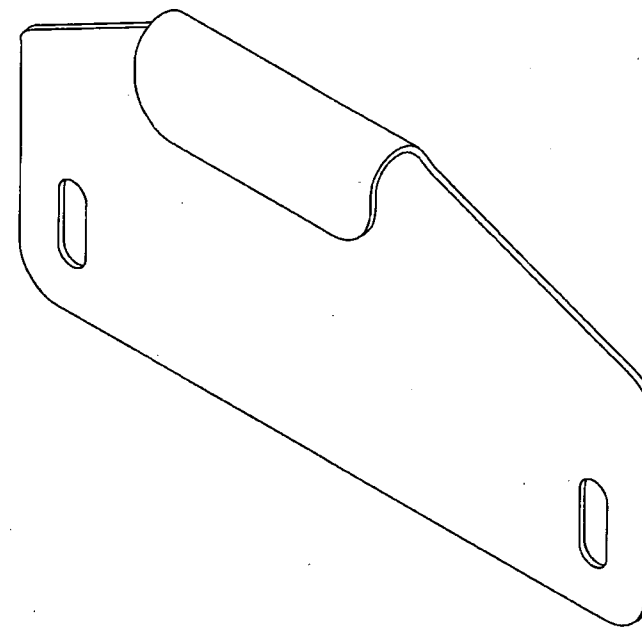
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3675-1 SLIDING DOOR BRACKET

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK
PER MIL-S-5059 (ANNEALED)
REF. DART SPEC M304S
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3675-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.15 lbs
- 8) THE D3675-1 SLIDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-1 BRACKET.

A	NEW ISSUE	AJS	08.03.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	ASS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3675	SHEET 1 OF 2
APPROVED		TITLE	SLIDING DOOR BRACKET SCALE
DE APPR.		(COMPOSITE DOOR)	NTS
DATE	08.03.27	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42515

RELEASED
08-06-26/11

8

7

2

1

D

D

2.78

58

C

C

B

B

3.61

2.92

2.65

1.73

1.63

R0.105
REF

A

A

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08-06-26 1/11

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D3675

REV. A

SHEET 2 OF 2

TITLE **SLIDING DOOR BRACKET**
(COMPOSITE DOOR)

SCALE
NTS

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8

7

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